



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3389-1
Job Sheet 176086



Part No: D3389-1

Job Qty: 5 ea

Part Name: Web



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/16/18

Job Tracking No:

Due Date: 4/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP Rev:A 05.08.31 New issue KJ/JLM IPP Rev:B 06-02-08 As per Rev C JLM IPP Rev:C 07-11-13 ECN 1056 Rev D dwg DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea		4/28/18	0.00	0.00	Start Up Skidtubes-1		
100	Skidtubes	5 pcs		4/28/18	0.00	3.03	Skidtubes-3		OD Mlnh
110	QC	5 pcs		4/28/18	0.00	0.00	QC5		DE
120	HandFinish	5 pcs		4/30/18	0.00	1.08	HandFinish1		SA 18-0419
130	QC	5 pcs		4/30/18	0.00	0.00	QC7-2		JU
140	Packaging	5 pcs		4/30/18	0.00	0.00	Packaging3-1		AT
150	QC21-SA	5 Ea		4/30/18	0.00	0.00	QC21		

Part Op 100 - 1- Pick D2500-3-100 3- Locating from deburred end, drill pilot holes using DT8785 as per dwg D3389. Scribe cut
Descriptions: line. 4- Cut to finished length 5- Open holes to finished size as per dwg D3389 6- Deburr
140 - LOCATION : LG002

APR 25 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2500-3-100	Ext'n - 'I' Beam Web 4"	5 Ea (1 ea)	90-Start up Operation	5036056

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2500-3-100	5	75	0

Part Specifications

Specifications could not be found.

Plex 4/16/18 3:04 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS					
	Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
	Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
	Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
	Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			

Date : _____ Step #: _____

Description Work Order Deviation

2) Approval

By _____ Supervisor Verification

Coordinator Approval

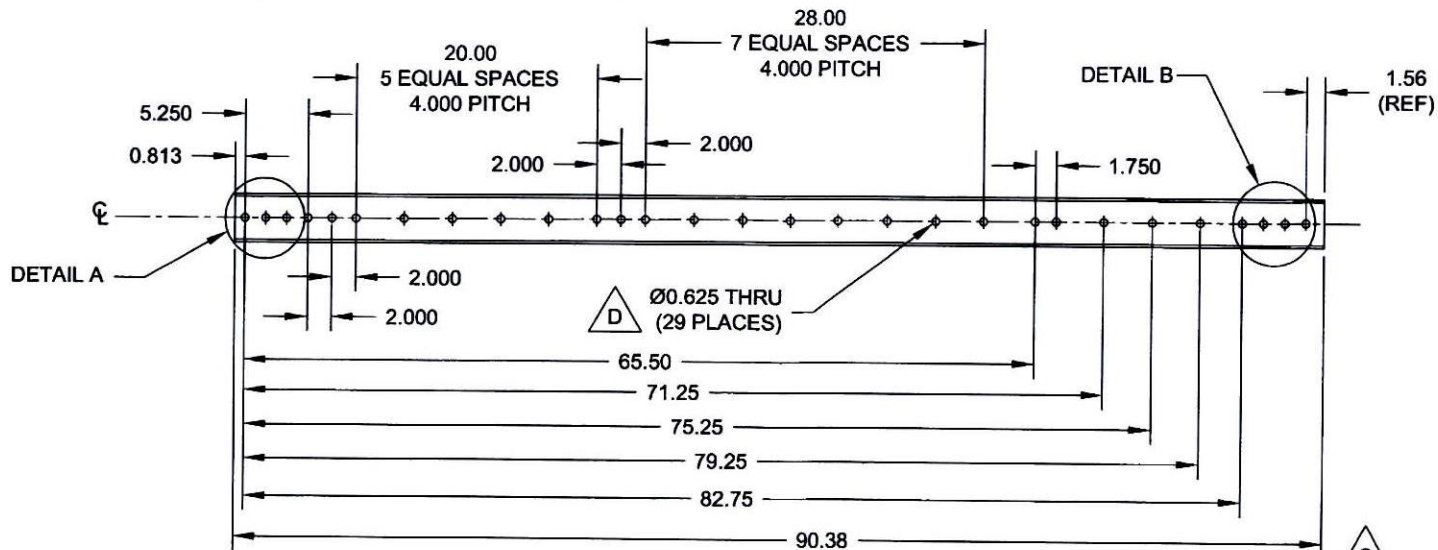
Part: D3389-1
Job No: 176086
Serial No/Batch: S062811

Revision: _____
Inspector: _____

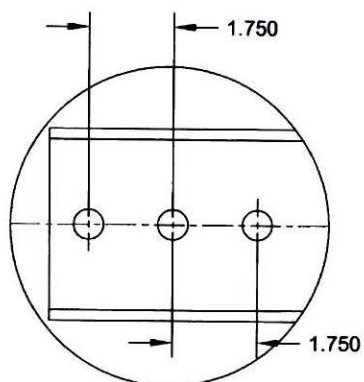
Date: 04/19/18

DART Aerospace Ltd.
1270 Aberdeen Street
Hewitburg, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

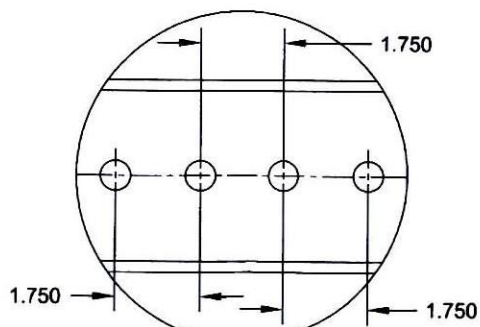
Root Cause			
Environment ☐	No Re-verification ☐	Pressure/Force ☐	Wrong dimensions or tolerance ☐
Design ☐	Operator ☐	Bending ☐	Part incorrect ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Cor ☐	Part Lost/Missing ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Part Moved ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Drawing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Finish ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Misread ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Turning Sequence ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐	OTHER : _____	



D3389-1 412 WEB



DETAIL A
SCALE 2:5



DETAIL B
SCALE 2:5

NOTES:

- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.6 lbs

RELEASED
07.11.06 MJD

D	REVISE HOLE DIAMETER FROM Ø0.257 TO Ø0.625, ZONE D4; REFORMAT DRAWING	PH	07.10.09
C	DECREASE OVERALL LENGTH, MODIFY HOLE	PH	06.01.23
B	UPDATE DIMENSIONING	PH	05.06.13
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.09		

DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. D3389
REV. D
SHEET 1 OF 1
TITLE 412 WEB
SCALE 1:10

COPYRIGHT © 2005 BY DART AEROSPACE USA, INC
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																								
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____	
Misidentified ☐	Past Due ☐																																																														